

5/25

3

DART AEROSPACE LTD	Work Order:	23306
Description: Doubler 04.11.25 #8 Dwg: D3302 Rev. A BK	Part Number:	D3302-1
04.11.25 #8 Dwg: D3302 Rev. A BK	Qty:	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Note: To be made in multiples of 10</b>	KJ	05.05.20	20
2	MV	Cut blank: 12.900" x 7.850" <i>3.150"</i> Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3302-1	SG	05/06/08	20
3	MV	Machine as per Folio FA450 and Dwg D3302 Stack of 10 Identify as D3302-1	JL	05/06/10	20
4	QC2	Inspect parts as they come off the CNC machine	JL	05/06/10	20
5	QC8	Second check	EC	05.06.10	20
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	FT	05/06/10	20
7	GB	Form as per Dwg D3302	SB	05/08/25	20
8	QC5	Inspect work to Step 7	Z	05-09-01	20
9	FP	Chemical Conversion Coat as per QSI 005 4.1	DMC	05-09-9	20
10	QC3	Inspect Chemical Conversion Coat	ML	05-09-12	20
11	ST	Identify and Stock	DL	05/09/13	20
12	AC	Cost / part <u>16.99</u>	SAC	05-09-14	20
13	DC	Close W/O <u>16.04</u> Inspect Level 21		05/08/14	20

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	

RELEASED  
04-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

No DQA:   Date: 05/09/14

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	Z3306
Description: Doubler	Aero 5-2 Rev B	Part Number:	D3302-1
Inspection Dwg: D3302	Rev: B+2		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article      Prototype

Measured by:	J.L	Audited by:	R	Prototype Approval:	N/A
Date:	05/06/10	Date:	05.06.10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.03.04	Revised dimensions per Dwg revision	KJ/JLM	

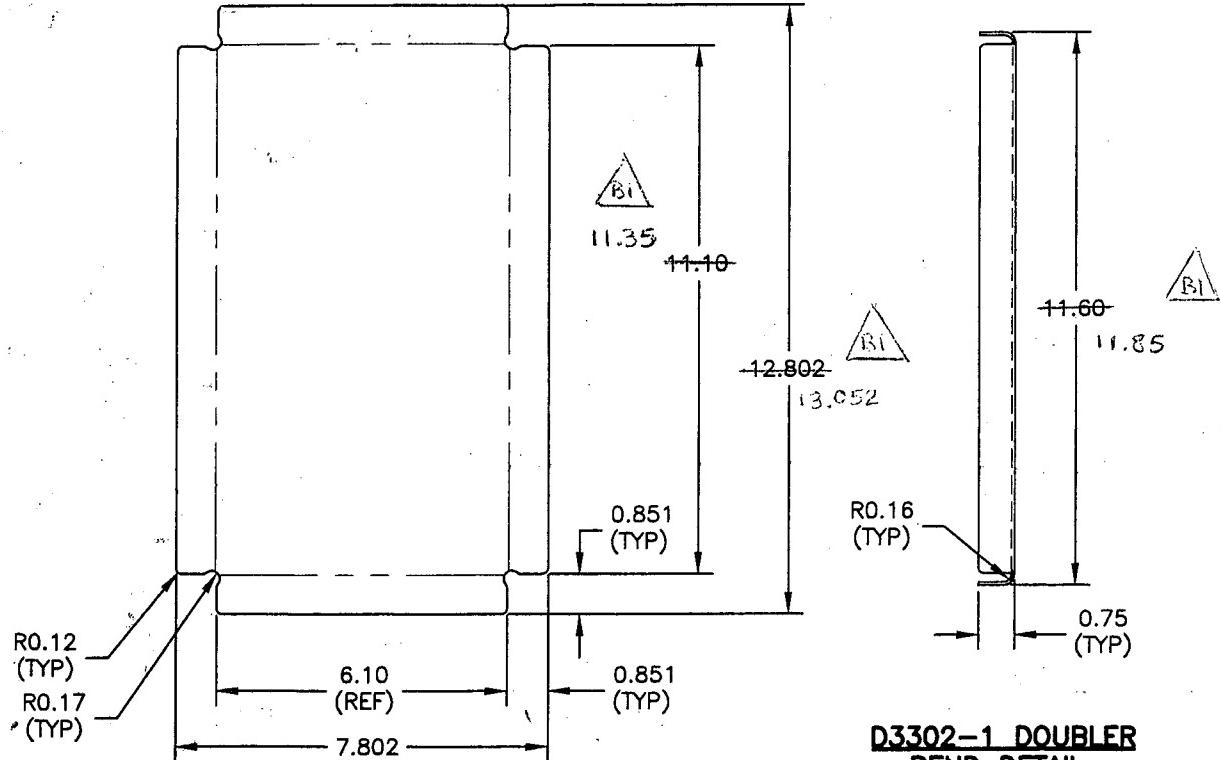
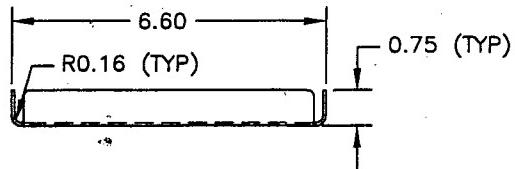
RELEASED  
05-03-08

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. B
		D3302	SHEET 1 OF 4
DATE		TITLE	SCALE
04.11.18		DOUBLER	1:4

**RELEASED**  
04.11.23 *[Signature]*

A	04.07.06	NEW ISSUE
B	04.11.18	REMOVE HOLES
B1	<del>RF</del> 04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/-3
B2	<del>RF</del> 05.03.21	7.25 WAS 7.34 ; 8.952 WAS 9.042 ; 7.75 WAS 7.84 FOR D3302-3

**D3302-1 DOUBLER  
BEND DETAIL****D3302-1 FLAT PATTERN****SHOP COPY**RETURN TO  
ENGINEERING**UNCOATED COPY**  
SUBMIT DOCUMENT  
FOR APPROVAL**WORK ORDER****D3302-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

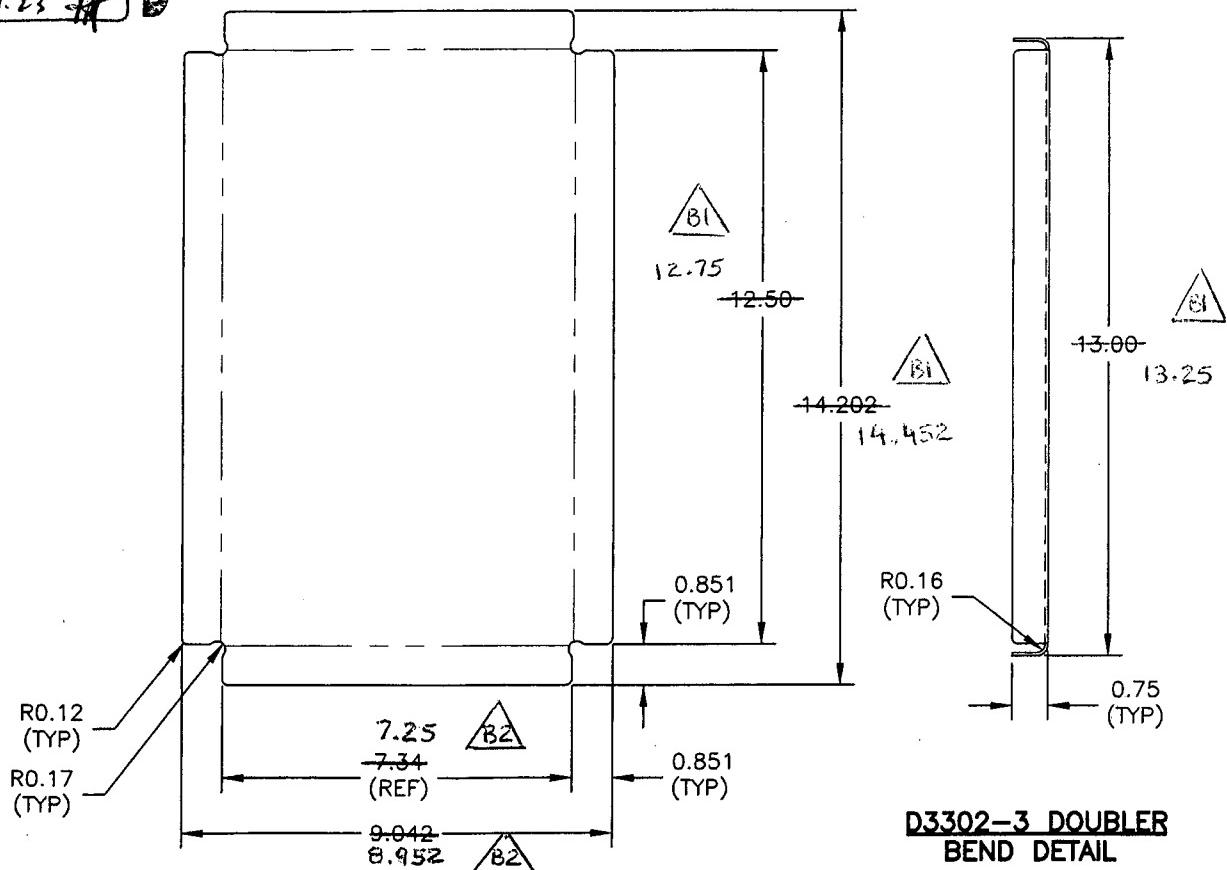
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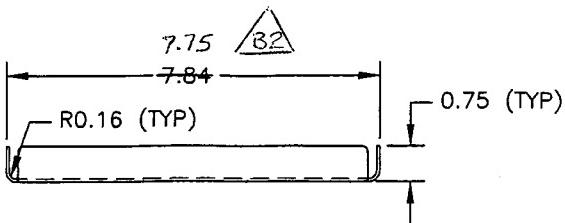


DESIGN <i>R.F.</i>	DRAWN BY <i>R.F.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18	TITLE DOUBLER	SCALE 1:4	

A black rectangular stamp with the word "RELEASED" at the top in large, bold, sans-serif capital letters. Below it is a horizontal rectangular box containing the date "04.11.23". Underneath the date box is another horizontal rectangular box, which appears to contain a handwritten signature that is mostly illegible but includes the letters "PF".



**D3302-3 FLAT PATTERN**



**D3302-3 DOUBLER  
BEND DETAIL**

SHOP COPY

CHURCHES

2. APPENDIX

U.S. AIR FORCE

S. 177

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卷之三

233

C. M6061T6S.063)

#### **MARKER**

[View all posts by admin](#) | [View all posts in category](#)

BE USED FOR ANY PURPOSE

ROSPACE LTD.

Digitized by srujanika@gmail.com

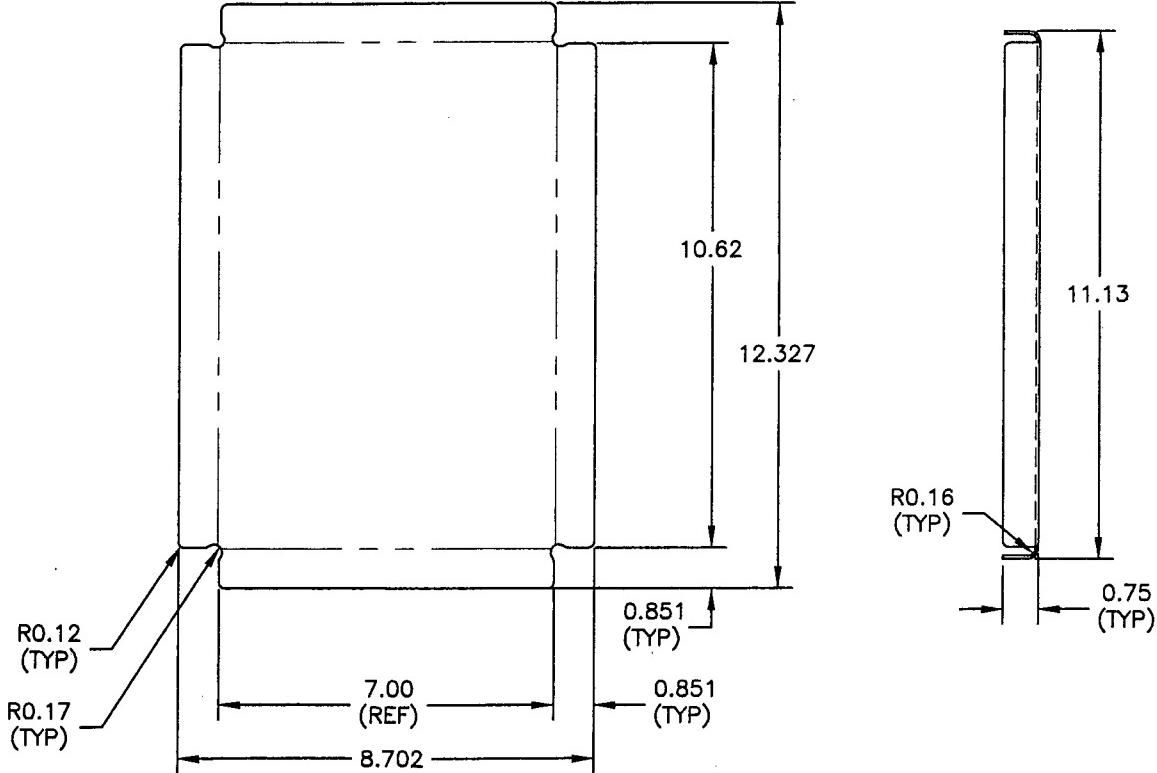
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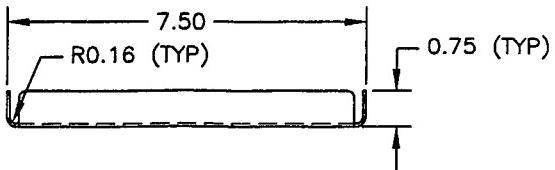


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3302
DATE 04.11.08	TITLE DOUBLER	REV. B SHEET 3 OF 4 SCALE 1:4

RELEASED  
04.11.23 *[initials]*



D3302-5 FLAT PATTERN



D3302-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

D3302-5 DOUBLER  
BEND DETAIL

SHOP COPY

PRINT TO

6 MM 3 G

UNIT TT COPY

SUB JOURNAL DOCUMENT

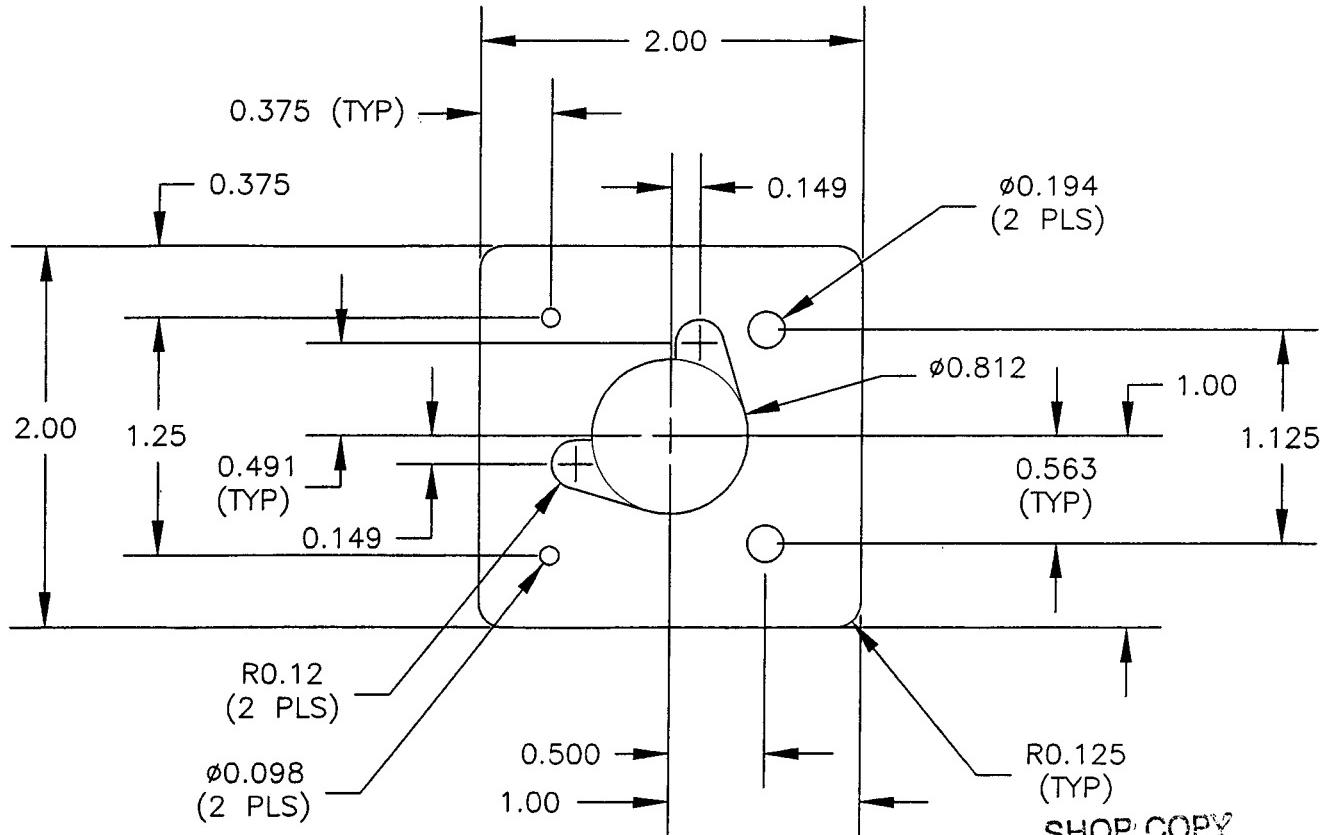
ATTACH NOTICE

WORK ORDER

NO. 23306

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3302
DATE 04.11.18		TITLE DOUBLER

REV. B  
SHEET 4 OF 4  
SCALE  
1:1**RELEASED**  
04.11.23 *[initials]*D3302-7

W/COPY  
RETURN TO  
ENGINEERING  
UNLTD  
S: 77  
F: 1  
Z3306

D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11) *Z3306*  
0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 12, 2005  
04:28 pm

Work Order No : 0023306  
 Project Name : D3302-1  
 Project For : WK525  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3302-1  
 Description : Doubler  
 Manufactured : Yes  
 Amount Req'd : 20  
 Amount Done : 0  
 Start Date : 05-12-05  
 Est Finish Date : 06-23-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00